

Date: May, 3/28/2006 3:00:01 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B FWD X-TUBE
Job Number	: 26378	Part Number	: D206667101
Estimate Number	: 12346	Drawing Number	: D206-667-141REV B
P.O. Number	: <i>N/A</i>	Project Number	: N/A
This Issue	: 3/28/2006 S.O. No. : <i>N/A</i>	Drawing Revision	: B
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : LANDING GEAR	Due Date	: 4/30/2006
Previous Run	: 26378	Qty:	1 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-101 CHG002.

2.0	D6001105	Crosstube
-----	----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1-D6001-105 Crosstube B 23965

Check OD = 2.250"; ID = 1.874"

B6 06.04.24

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA083

2-Turn first side as per Folio FA083

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141.

B6 06.04.25 1

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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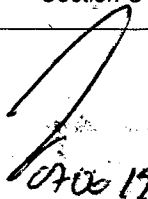


Comment: INSPECT ALL DIM TO DIM SHEET

B6 06.04.25 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE*(NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-04-25	3+5	Paper and cuff still had turns end of tube .312" on each side. Error was made in test offset on 1st side. 2nd side turned to match 1st side	 06-04-25 QSI/47	Tool offset corrected.  Machine tube symmetrical with it, in correct location, ensure smooth transition near cuff where tool runs off part. See email	B6 06-04-25	 07-06-15		

NOTE: Date & initial all entries

Date: Tuesday, 3/28/2006 3:00:01 PM  
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Drawing Name: 206B FWD X-TUBE

Job Number: 26378

Part Number: D206667101

Job Number:



Seq. #: Machine Or Operation: Description:

5.0 MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA083

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141.

~~3-Polish entire outside surface of crosstube~~

4-Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-141

07-05-12

①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

07-05-12

①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07/05/12

①

8.0

HAND FINISHING

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per GSI 0054.1

QC 5 inspect

DP 7-6-5

9.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-141 using CNC bender program 206B-fw and Folio FT

EL 7-6-5

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07-06-12

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill all (3) top holes.

2-Drill & ream holes as per Dwg D206-667-141 using drill Jig DT8575 & DT8576. Drill all (3) top holes.

P10

Handwritten notes in the top left corner, including the word "e" and some illegible scribbles.

Handwritten notes in the top center, including the word "e" and some illegible scribbles.

Handwritten notes in the middle left section, including the word "e" and some illegible scribbles.

Large section of handwritten notes at the bottom of the page, including the word "e" and extensive illegible scribbles.

Date: Tuesday, 3/28/2006 3:00:01 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 26378

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-141. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-141.

Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.

8-C'sink holes as per Dwg D206-667-141. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141

EL  
7-6-22

JB 7-6-25

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Force 25 (1)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JB 7-6-25

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Force 26 (1)

15.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 4043 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

CL 7/10/24 (1)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

CL 7/5/25 (1)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
070517	7.1	Polish outside surface of tube within the limits	JD	7-5-17				
		Added to estimate perm. change	JD	7-5-17		070517	070517	
070517	7.2	chemical conversion cost per QSI005	pmc	07-5-17	1			
	8.0	sold QCS perm change				070517	070517	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 26378

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

En 07/06/03

18.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

19.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

MA 070707

20.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total: 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip

32020 85 07-07-07

21.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

29286 MA 070705

22.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate

30450 MA 070705

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206B FWD X-TUBE

Job Number: 26378

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

28388

RT 07-07-07

24.0

MS20601AD4W8



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

102850

ML 070705

25.0

MS2192020

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

102712

RT 07-07-07

26.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-141. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-141. Touch-up rivet heads with Imron paint.

ML 070707

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206B FWD X-TUBE

Job Number: 26378

Part Number: D206667101

Job Number:



Seq. #: Machine Or Operation: Description :

29.0 AN532A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M15072 ✓

30.0 MS21042L5 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M15072 M103446 ✓

31.0 AN57A Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-7A

Bolt

M103446 M103389 ✓

32.0 AN530A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt

M102473 ✓

33.0 AN960JD516 Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN960JD516

Washer

M103694 ✓

34.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-101

Location: e

PPP Rev: e

C207107109 7/7/95 59

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 206B FWD X-TUBE

Job Number: 26378

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

①  
D 07/07/10

Job Completion



07/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-141	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05.07.26

Qty	Part Number	Description
X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
1	D6001-105	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6001-105  
FINISHED LENGTH =  $93.18 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

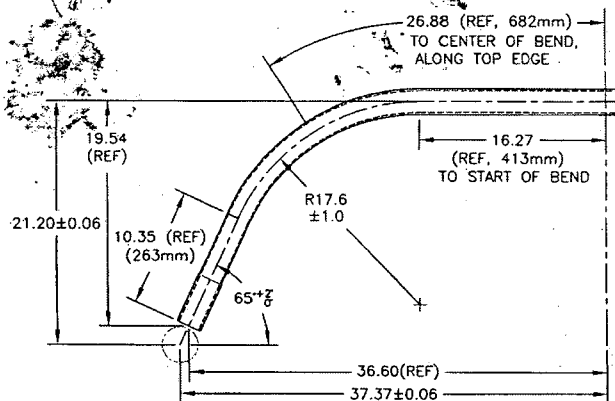
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26378

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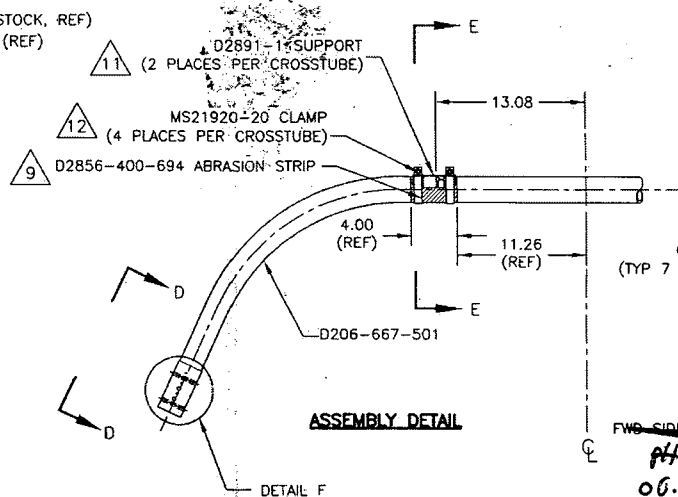
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**BENDING DETAIL** (6)

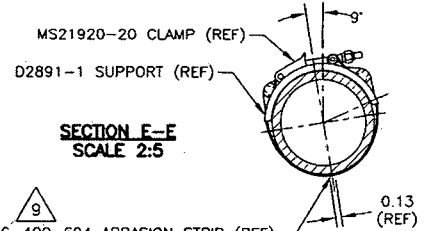


**ASSEMBLY DETAIL**

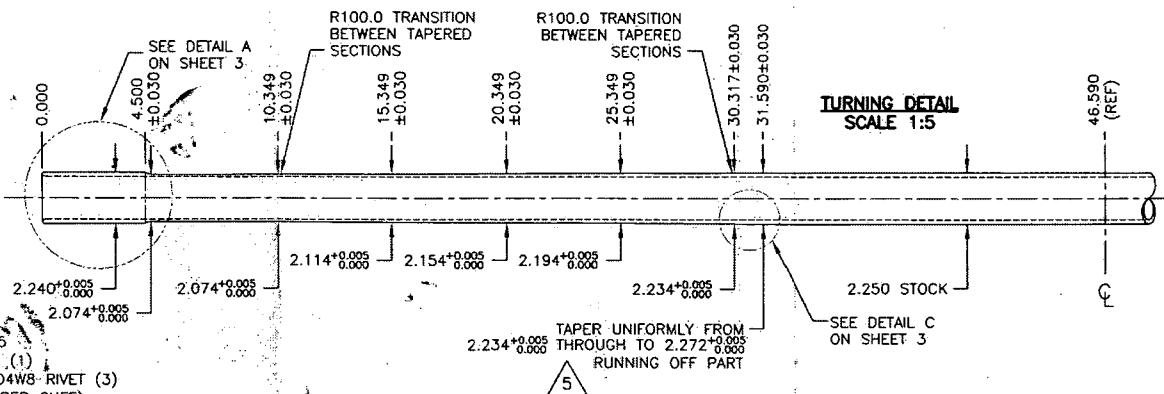
Ø0.323<sup>+0.005</sup><sub>-0.000</sub> (TYP 5 PLACES PER CUFF)  
HOLE TO BE ALIGNED WITHIN ±0.001 OF HOLE ON OTHER SIDE OF CUFF

PILOT Ø0.128 C'SINK Ø0.225X100' (TYP 7 PLACES PER CUFF)

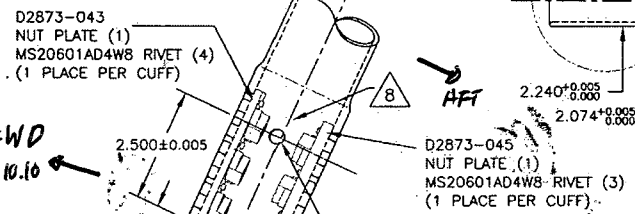
**TURNING DETAIL** SCALE 1:5  
FWD SIDE ONLY  
PH 06.10.10  
AFT VIEW  
USE FOR FWD SIDE



**SECTION E-E** SCALE 2:5



**TURNING DETAIL** SCALE 1:5



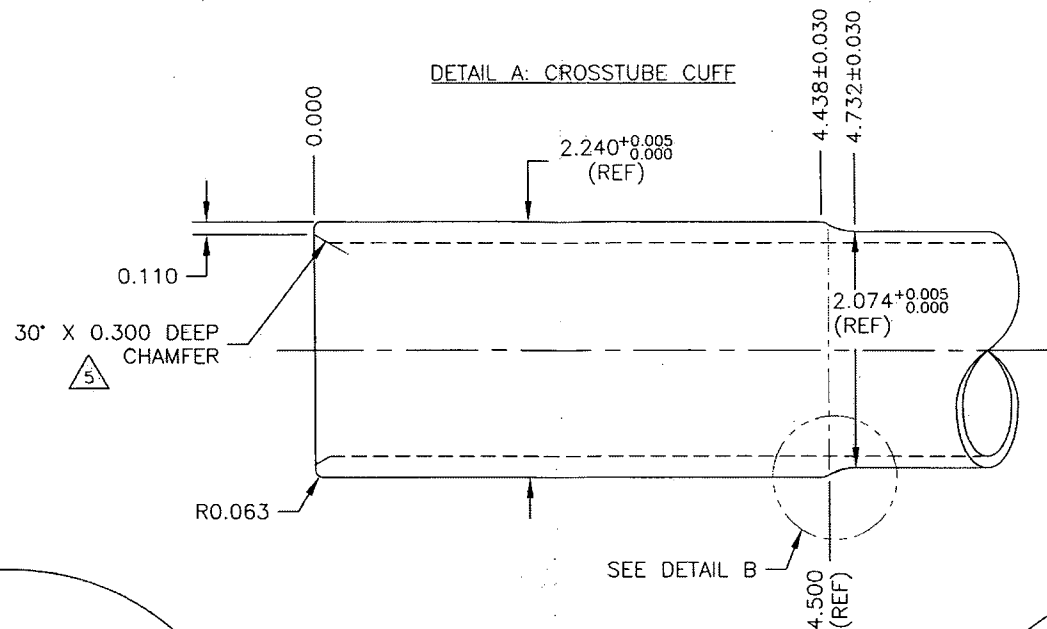
**VIEW D-D**  
**CUFF DETAIL**  
SCALE 2:5

**RELEASED**  
05.07.26

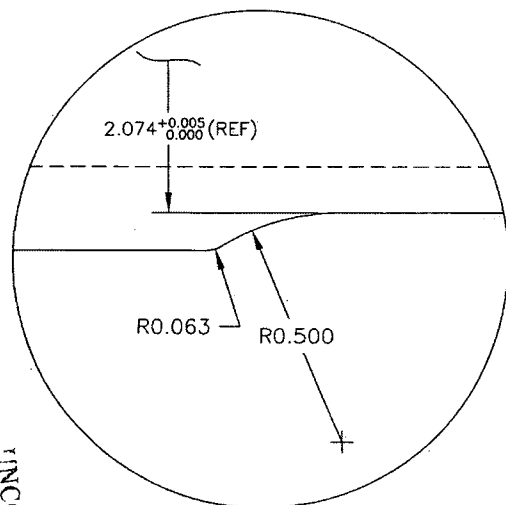
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CHECKED DS		APPROVED DS		DRAWING NO.	REV. B
DATE 05.07.26				D206-667-141	SHEET 2 OF 3
				TITLE	SCALE
				CROSSTUBE ASS'Y (206B HIGH FWD)	1:10

NO 26318  
FWD 05.10.10  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

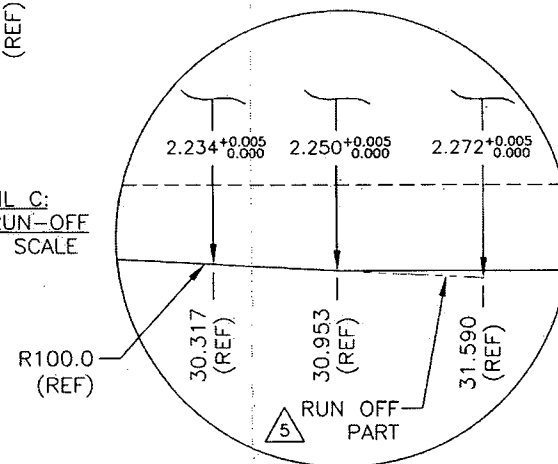




RELEASED  
05.07.26



DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE

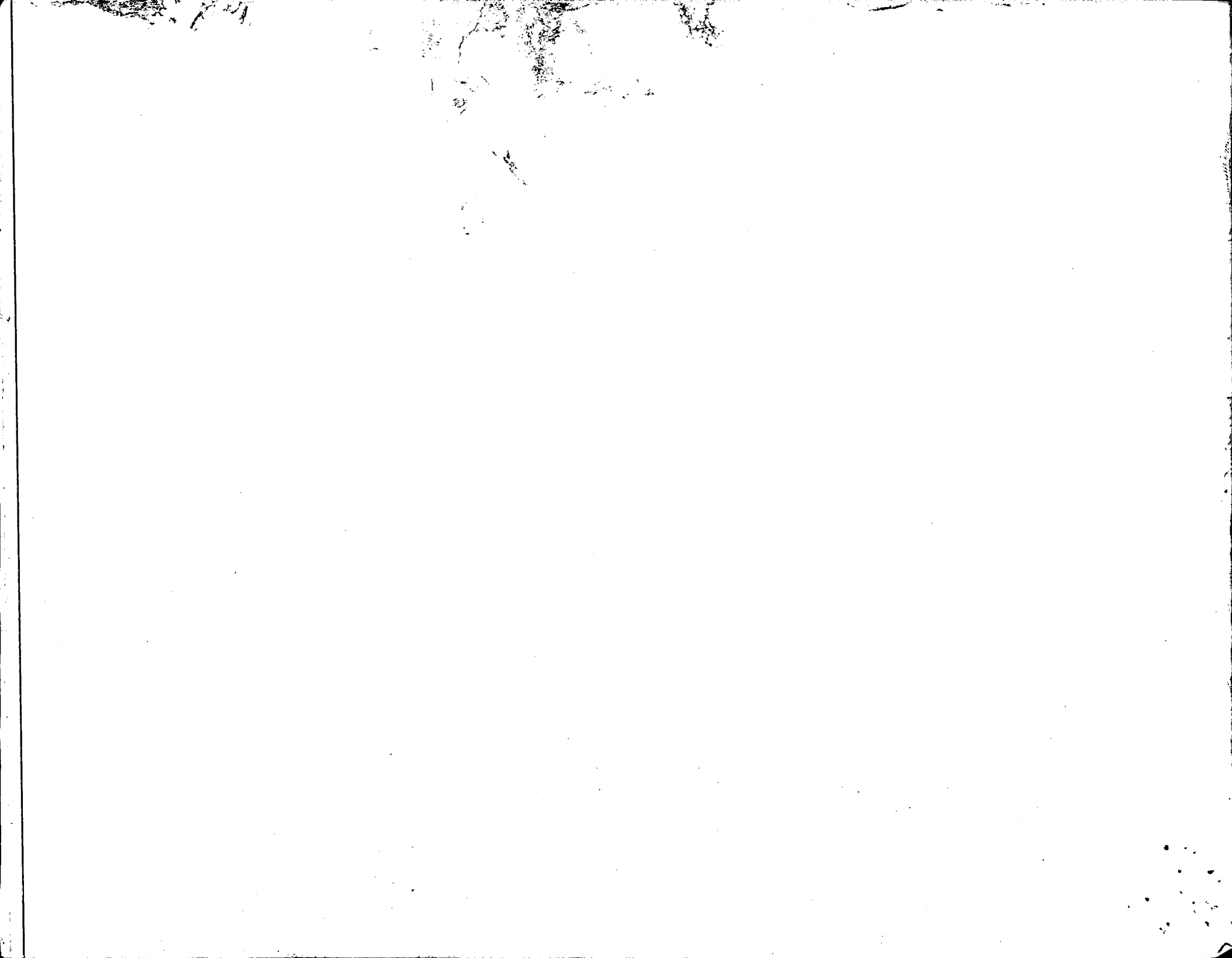


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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
PH	PH		MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. B
#DS	#DS	D206-667-141	SHEET 3 OF 3
DATE	TITLE	SCALE	
05.07.26	CROSSTUBE ASS'Y (206B HIGH FWD)	1:1	

NO. 26378  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 26378
<b>Description:</b> Crosstube Assembly		<b>Part Number:</b> 0206-667-101
<b>Inspection Dwg:</b> 0206-667-141 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	$\pm .005$	2.241	✓			
	2.074	"	2.075	✓			
	2.114	"	2.117	✓			
	2.154	"	2.158	✓			
	2.194	"	2.196	✓			
	2.234	"	2.236	✓			
	R.063	$\pm .010$	.063	✓			
	.110	"	.120	✓			
	4.438	$\pm .03$	4.126		X		See E-mail
SIDE B	2.240	$\pm .005$	2.242	✓			
	2.074	"	2.076	✓			
	2.114	"	2.119	✓			
	2.154	"	2.157				
	2.194	"	2.196	✓			
	2.234	"	2.236	✓			
	R.063	$\pm .010$	.063	✓			
	.110	"	.110	✓			
	4.438	$\pm .03$	4.126		X		See E-mail
	93.18	$\pm .02$	93.180	✓			

<b>Measured by:</b> BG	<b>Audited by:</b> J.L.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06.04.25	<b>Date:</b> 07/05/12	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	



## Chris Provencal

---

**From:** David Shepherd [davids@dartaero.com]  
**Sent:** April 28, 2006 10:11 AM  
**To:** Chris Provencal  
**Subject:** Re: D206-667-141

I agree with re-machining the tube as you have outlined below.

David

----- Original Message -----

**From:** "Chris Provencal" <cprovencal@dartaero.com>  
**To:** <davids@dartaero.com>  
**Sent:** Friday, April 28, 2006 7:20 AM  
**Subject:** NCR: D206-667-141

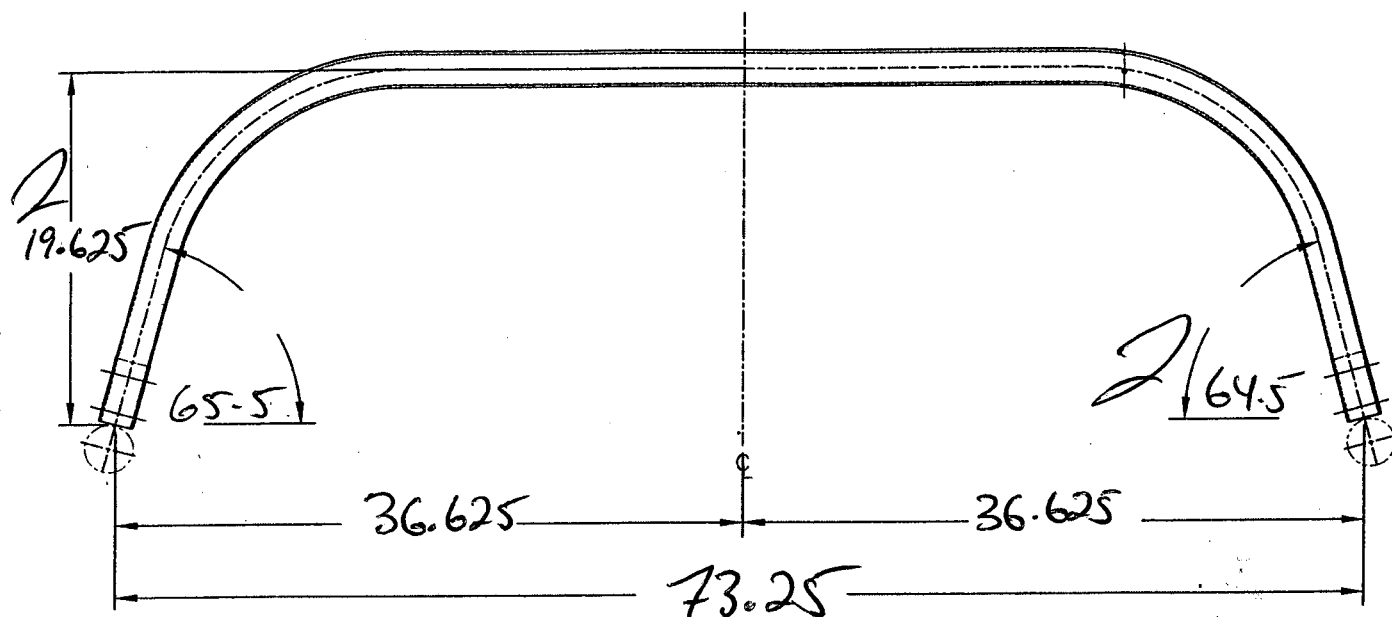
> David,  
>  
> One D206-667-141 crosstube. The cuff was machined only 4.130" long  
> (should  
> be 4.438 to beginning of rad at top of cuff). The entire taper has  
> essentially been shifted outward so the tube is effectively thicker in most  
> places.  
>  
> There would only be 0.310" from the end of the saddle to the end of the  
> cuff  
> now.  
>  
> They did something like this before, we had them run the program again  
> correctly and had them do a flat section near the shorter cuff. The  
> tube  
> would also have to be machined symmetrical so both cuffs are short.  
>  
> Are you OK with 4.130" cuff length if they re-machine the taper in the  
> correct location and add a flat section that maintains the minimum OD of  
> 2.074" near the cuff?  
>  
> Sincerely,  
> Chris Provencal  
> DART Aerospace Ltd.  
> Email..cprovencal@dartaero.com  
> Phone...613-632-3336  
> Fax.....613-632-4443  
>  
>





DART AEROSPACE LTD		Work Order:	26378
Description: Crosstube High Fwd (206B)		Part Number:	D206-667-101
Inspection Dwg: D206-667-141 Rev: B		Page 1 of 1	

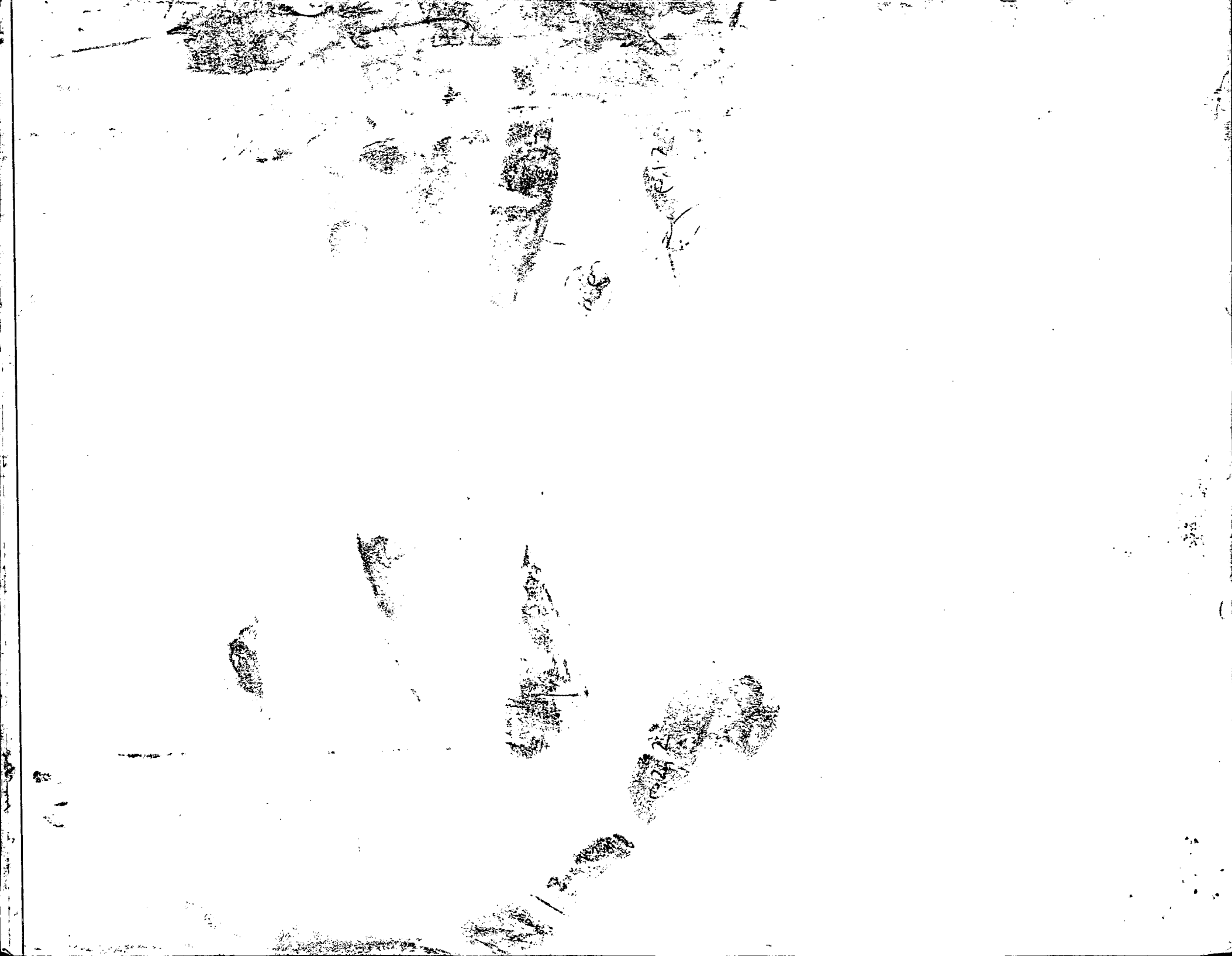
Required Dimension	Min	Max
Height	19.48	19.60
1/2 Span	36.54	36.66
Angle	65	67
Total Span	73.08	73.32

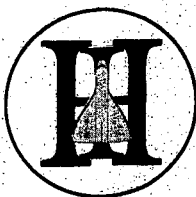


Comments

QC15 Inspection	<i>[Signature]</i>
Date	02.06.19

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>





# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36761

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of six (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (2) P/N D412-664-146 S/N's B32444 & B32443

Qty. (2) P/N D206-667-203 S/N's B32143 & B32144

Qty. (1) P/N D206-667-103BL S/N B32666

Qty. (1) P/N D206-667-101 S/N B26378

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on six (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive) Ardrex 970P25E Batch #04B503.

Five (5) cross tubes PASSED inspection and one (1) FAILED inspection, P/N D206-667-203, S/N B32144.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

S. FLETCHER

DATE June 26, 2007

INSPECTION STAMP(S) Not Required

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

4043

ADDRESS:

CONTACT NAME:

LABOUR	@	\$
MATERIALS	@	
TRAVEL EXPENSES	@	GST
HOTEL EXPENSES	@	PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT